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4.5NR-38D2
Job Sheet 183092



Part No: 4.5NR-38D2

Job Qty: 20 ea

Part Name: Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/12/18

Job Tracking No:

Due Date: 9/19/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 4.5NR-38 REV.2 IPP REV:A 18.09.NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		9/19/18	0.00	0.00	Start Up Waterjet		<i>2</i> 18/09/13
100	Waterjet	20 pcs		9/19/18	0.25	2.00	Waterjet1		<i>2</i> 18/09/13
110	QC	20 pcs		9/19/18	0.00	0.00	QC2 Waterjet-4		<i>2</i> 18/09/13
120	QC	20 pcs		9/19/18	0.00	0.00	QC8		<i>38</i>
130	Brake NC	20 pcs		9/19/18	0.25	6.67	Brake NC 1		<i>8</i> 9-89 <i>DAS</i>
140	QC	20 pcs		9/19/18	0.00	0.00	QC5		<i>38</i>
150	Packaging	20 pcs		9/19/18	0.00	0.00	Packaging3 Large Fab		<i>2</i> 9-89
160	QC21-SA	20 Ea		9/19/18	0.00	0.00	QC21		<i>DAS</i>

Part Op 100 - 1-Cut -38D1_38D2 as per Dwg Dwg Rev: 2 Prog Rev: 2 2-Deburr if necessary

Descriptions: 130 - Form as per dwg

21
9-89

OCT 16 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M1010S.125	1010-1025 Sheet .125	.1760 sf (.0088 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M1010S.125	0	6	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

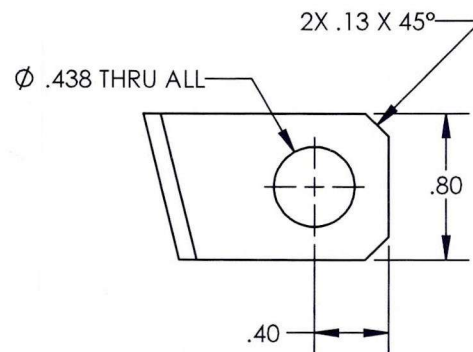
QA Closed: _____ Date: _____

Work Order update only ☐

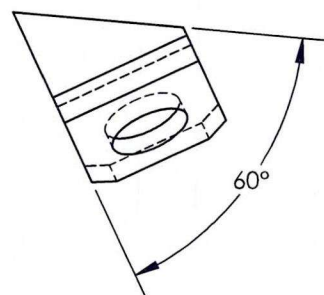
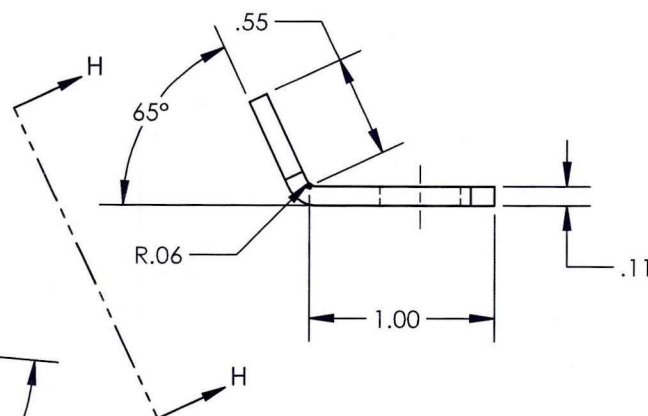
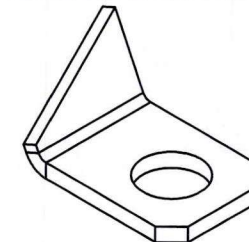
Work Order: _____ Part No. _____ NCR No. _____ Date : _____ Step _____		DISPOSITION Rework ☐ Scrap ☐ Use as is ☐		AGAINST DEPARTMENT/PROCESS Skid-tube Machining ☐ Cross tube Small End ☐ Water Jet ☐ Engineering ☐ Quality ☐ Other ☐						
Description Work Order		DART AEROSPACE Container No: S109830 Part: 4.5NR-38D2 Job No: 183092 Serial No/ Batch: S109830 Revision: 2 Inspector: _____ Exp Date: _____ Instructions: _____ Date: 09/13/18								
		MRB (QSI042) Approval _____								
		Completed By _____								
		Lead hand / Supervisor Approval Verification _____								
		QC / QA Coordinator Approval _____								
Root Cause <table style="width:100%;"> <tr> <td style="width:50%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table style="width:100%;"> <tr> <td style="width:33%;"> Pre ☐ Be ☐ Centre not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:33%;"> BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> <td style="width:33%;"> Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> </tr> </table>				Pre ☐ Be ☐ Centre not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐
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		OTHER : _____								

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
1	15-0019	4.5NR-38D2 CH'D MAT'L WAS 303 IS 1006-1026. CH'D DIM WAS (.094) IS (.090).	1/22/2015	DPD
2	15-0082	4.5NR-38D2 CH'D DIMS WAS (.090) IS .11, WAS .45 IS .55, WAS 1.500 IS 1.600, WAS 1.038 IS 1.138.	5/12/2015	JAG



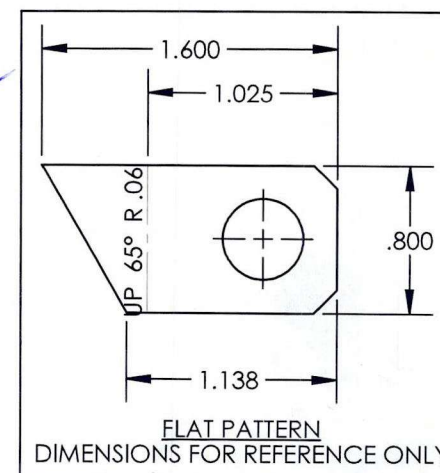
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 183092 MWS
18-09-12



VIEW H-H

4.5NR-38D2

BRACKET



DART AEROSPACE	
TITLE FUNNEL SUB-ASSEMBLY	
DWG NO. 4.5NR-38D2	REV 2
MAT'L 1006-1026	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weik</i>
.XXX ± .010 FRACTIONS ± 1/8	HEAT
.XX ± .03 ANGLES ± 5°	TREAT
.X ± .1	FINISH
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
SCALE 1:1	DATE 12/23/1997
SHEET 6 OF 6	